

Date: Wednesday, 08/04/2009 10:46:52 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT BLADE FOLD ASSY WELDMENT
Job Number	: 47087		
Estimate Number	: 13503		
P.O. Number	:	Part Number	: PB674300109 GN
This Issue	: 08/04/2009 S.O. No. :	Drawing Number	: B6743001 P.6
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 45047	Material	:
Written By	:	Due Date	: 25/04/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>MF 09-04-08</u>		
Comment	: Est Rev:A 08-06-25 new issue DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001211	Square Tubing
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Square Tubing

batch:- B44989MF 09-04-27

2.0	PB6743001209	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Square Tubing

batch:- 47093MF 09-04-27

3.0	PB6743001201	Square Tubing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Square Tubing

batch:- 44990MF 09-04-27

4.0	PB6743001203	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Square Tube

batch:- B41907MF 09-04-27

5.0	PB6743001239	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Square Tube

batch:- 46633MF 09-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 47087

Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001235

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Outer Tube

batch:- 45260

MF 09-04-29

7.0

PB6743001229

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Outer Tube

batch:- 45258

MF 09-04-29

8.0

PB6743001213

Flanged Hook



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Flanged Hook

batch:- 41488

MF 09-04-27

9.0

PB6743001311

Restraint



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Restraint

batch:- 41502

MF 09-04-27

10.0

PB6743001277

Contoured Hinge Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Contoured Hinge Arm

batch:- 23828

MF 09-04-27

11.0

PB6743001243

Handle Arm Extension



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Arm Extension

batch:- H3332

MF 09-04-27

12.0

D34409

Tube Detent Clip Base (Supersedes B67-43)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tube Detent Clip Base

batch:- 41456

MF 09-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D344013

Bracket (Supersedes B67-43001-273)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket

batch:- 41452

MF 09-04-27

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001

\*\* ensure no burn thru after welding in tube -235 and -229 only where bushing -265 \*\*\*

09-05-1

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-05-040

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/05/04 0

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

\*\*\*in detail D, mask in between -311 prior to paint\*\*\*

\*\*\*mask 1.750" on the end of -243 prior to paint\*\*\*

\*\*\*mask inside of D3440-9 prior to paint\*\*\*

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

11:30

OVEN TEMPERATURE:

320°

FINISH TIME:

12:00

09/05/05 ①

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-5

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LVA

09-05-06 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/07 MF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-05-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

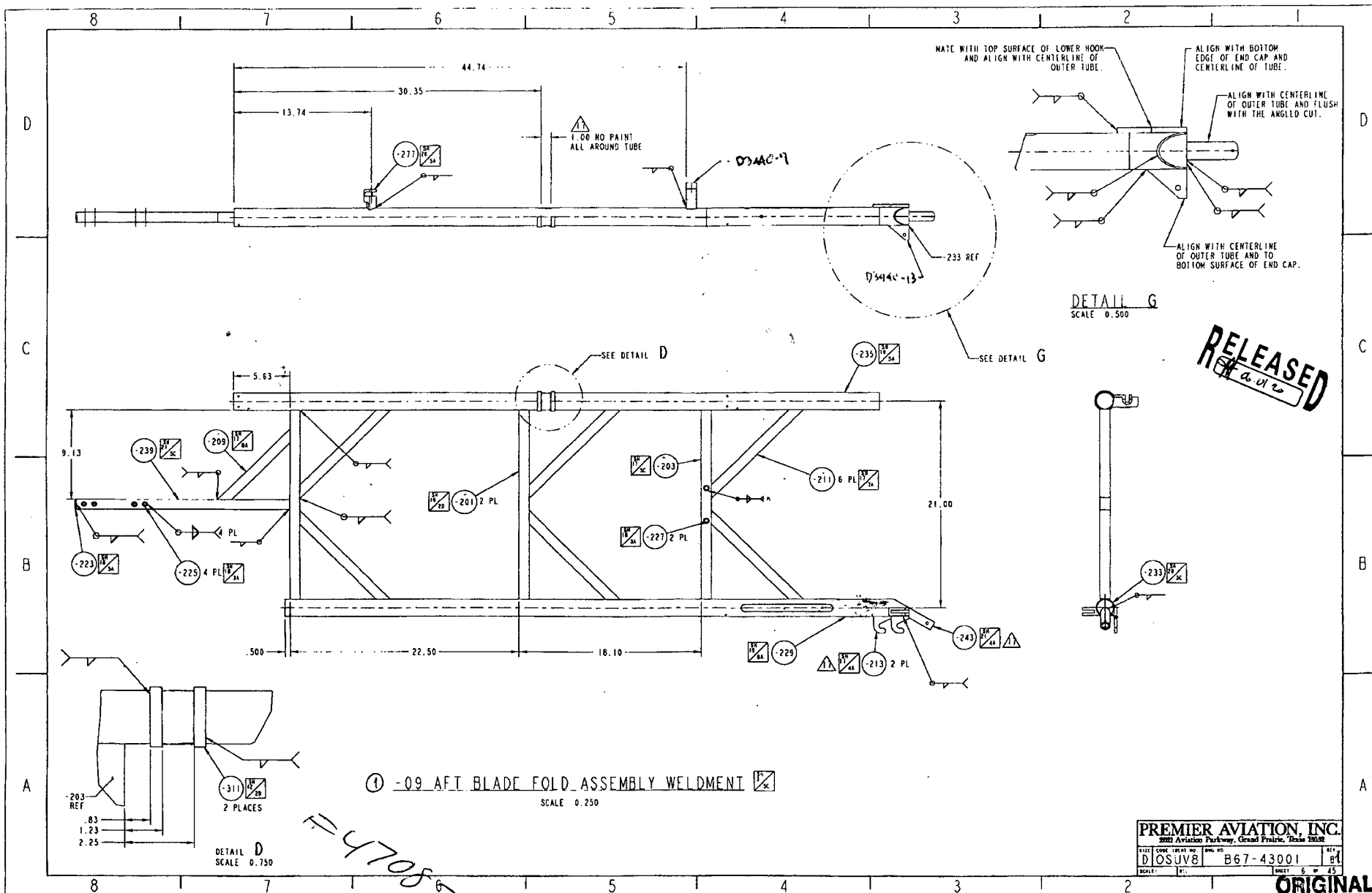
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





① -09 AFT BLADE FOLD ASSEMBLY WELDMENT

SCALE 0.250

F4708